

Work Order ID 79121

79121

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January-20-12 1:14:02 PM

Item ID: D3907-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bushing

Start Date: 20/01/2012 Start Qty: 40.00

40

Cust Item ID:

Required Date: 27/01/2012 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan: M.L.J Date: 12/01/20 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3907	A

100

0.00

100

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

Machine as per Folio FA823
& Dwg D3907

SL 12-01-23

Dwg Rev: A
folio Rev: _____
Deburr

40 0 PG 12/01/24

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

SL 12-01-23

40 0 PG 12/01/24

Pho →

W/O: 79121		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3907-1 PAR #: _____ Fault Category: Machining NCR: Yes No DQA: OK Date: 12/2/2
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: OK Date: 12/2/2

NCR:		WORK ORDER NON-CONFORMANCE (NCR) 5.33 X40 ~ 213.20						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/01/24	#110	Qty +40 (all) have bad hole size 0.257 measure 0.267 ~ 0.285. Due to chip on drill causing over size	SW 12/01/24 057042	Scrap + destroy Qty +40 (all) and replace m 1193416 Qty =	SL 12-01-23	H.A 12/01/24	W S 12/01/24 057042	S 12/01/24
		RL operator error / Process						

NOTE: Date & initial all entries

Work Order ID 79121

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Item ID: D3907-1 Accept ***N9000040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bushing
 Start Date: 20/01/2012 Start Qty: 40.00 ***40*** Cust Item ID:
 Required Date: 27/01/2012 Req'd Qty: 40.00 ***40*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

130	Identify as per dwg & Stock Location STWA	0.00							
130									
Packaging	Memo	0.00							
Packaging	*****STOCK IN BASKET CELL*****								

140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MF
12-01-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 79121

79121

Parent Item: D3907-1

D3907-1

Parent Item Name: Bushing

Start Date: 20/01/2012

Required Date: 27/01/2012

Start Qty: 40.00

Required Qty: 40.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R0.375		Purchased	No			100	f	47.3470	0.03	1.2			

M304R0.375

304 ROUND BAR 0.375

**

12-01-23

Location	Loc Qty	Loc Code
MAT029	47.347	
119346	23.247	
120204	24.1	

1.2

119346

1.333 12/01/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

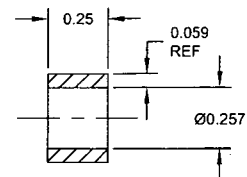
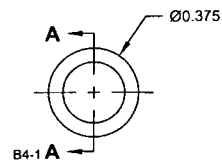
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3907-1 BUSHING

SECTION A-A C5-1

NOTES:

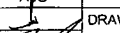
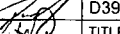
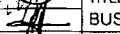

1) MATERIAL: AISI 304/316 STAINLESS STEEL ROD
REF DART SPEC M304R

OR: AISI 304/316 STAINLESS STEEL BAR
REF DART SPEC M304B

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

STANDARD
REV. 1
UNCUT
STANDARD
W
NO 79121425
12/01/20

RELEASED

A		NEW ISSUE		AJS		09.03.11	
REV.		DESCRIPTION		BY		DATE	
DESIGN		AJS		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN		AJS					
CHECKED				DRAWING NO.		REV. A	
MFG. APPR.				D3907		SHEET 1 OF 1	
APPROVED				TITLE		SCALE	
DE APPR.				BUSHING (BASKET REPAIR)		NTS	
DATE		09.03.11		COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>"THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD."</small>			

W/O:		WORK ORDER CHANGES						
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